

Covered Electrodes

K-9015B9W

For heat-resisting steel (9%Cr-0.5%Mo-Nb-W)

Classifications

AWS A5.5-15 : E9015-B92 H4R

Description

- Covering is low hydrogen type for welding of 9%Cr-0.5%Mo-Nb-W steel used in oil refining and chemical industries, heat treated high tensile strength steel for P92
- Preheat at 250~350°C and postheat treat at 720~770°C
- Excellent crack resistance because of low hydrogen contents.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

| C | Si | Mn | P | S | Ni | Cr | Mo | W | Nb |
|------|------|------|------|------|------|------|------|------|------|
| 0.11 | 0.27 | 0.62 | 0.01 | 0.01 | 0.26 | 8.93 | 0.51 | 1.72 | 0.05 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) | | Remarks |
|---------------------|-----------------|-----------------|---------------|--------|-----|---------|
| | | | | 20°C | 0°C | |
| AWS A5.5 Example | min. 530 670 | min. 620 780 | min. 17 20 | 50 | 35 | PWHT |

* PWHT : 760°Cx1Hr.

Sizes available and recommended currents (DC +)

| Dia. | (mm) | 2.6 | 3.2 | 4.0 | 5.0 | 6.0 |
|--------|--------|-------|--------|---------|---------|---------|
| Length | (mm) | 350 | 350 | 400 | 400 | 450 |
| Amp. | F | 50~90 | 75~115 | 120~160 | 160~210 | 210~260 |
| (A) | V · OH | 50~80 | 70~110 | 90~130 | — | — |